

Work Order ID 59437

Friday, June 04, 2010 10:24:25 AM



Page 1

Item ID: D3953-3

Accept



Setup Start



Revision ID:

Item Name: Gas Spring Stud, Lid

Stop



Start Date: 6/4/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-6-04 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

Draw Nbr	Revision Nbr
D3953	C

100



0.00

Doosan

Memo

0.00

Doosan Lathe

Turn as per folio FA852 & DWG
FOLIO REV: N/A
DWG REV: C

SL 10/06/17

DEBURR

110



QC2- Inspect parts off machine FAI/FAIB

0.00

SL 10/06/17

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59437

Friday, June 04, 2010 10:24:26 AM



Page 2

Item ID: D3953-3

Accept



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Item Name: Gas Spring Stud, Lid

Stop



Start Date: 6/4/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

88 10/06/17

20

/



QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: 102

0.00



Packaging

Memo

0.00

Packaging

10-6-17 200 sf

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/21 AF
MF 10-6-18

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, June 04, 2010 10:24:30 AM

Page 1

Work Order ID: 59437



Parent Item: D3953-3



Parent Item Name: Gas Spring Stud, Lid

Start Date: 6/4/2010

Required Date: 6/10/2010

Comments: IPP RevA: New issue DD verified by:EC
DD 10.03.02 verified by:EC

IPP Rev:B as per dwg revC

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304RO.750						100	f	54.5947	0.125	2.631579			

304 SS Roundbar .750



Location	Loc Qty	Loc Code
MAT028	54.59473684	
113216	20.3447368	
113457	34.25	

2.5 SL 10/06/11

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	59437
Description: Gas Spring Stud, Lid	Part Number:	D3953-3
Inspection Dwg: D3953 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	DL	Audited by:	LP	Prototype Approval:	N/A
Date:	10/06/17	Date:	10/06/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	09.12.14	Dwg Rev updated	KJ	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

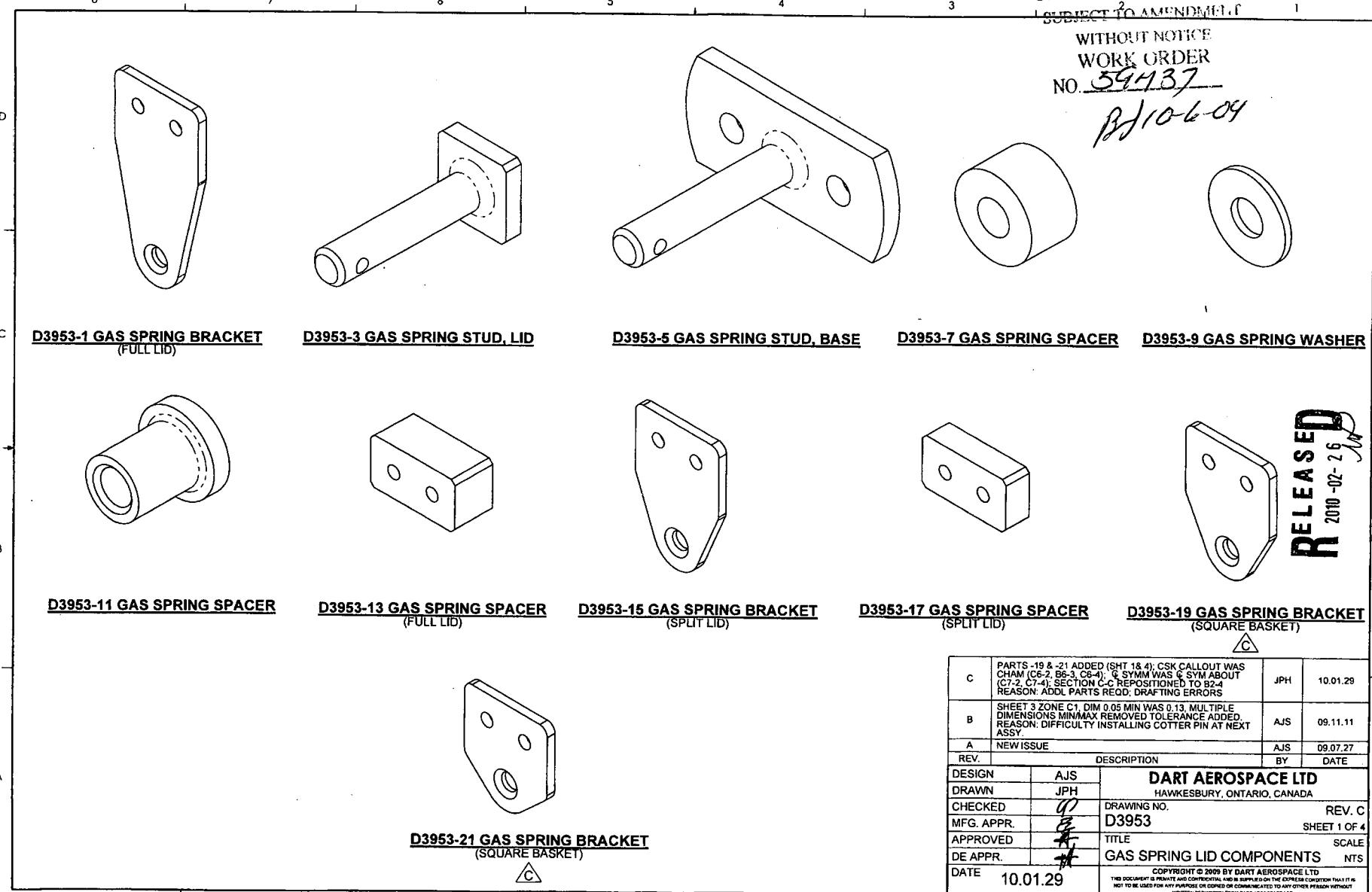
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 59437

BJ 10-6-09



RELEASED
2010-02-26

C	PARTS -19 & -21 ADDED (SHT 1&4); CSK CALLOUT WAS CHAM (C6-2, B6-3, C8-4); C SYM WAS C SYM ABOUT (C7-2, C7-4); SECTION C-C REPOSITIONED TO B2-4 REASON: ADDL PARTS REQD; DRAFTING ERRORS	JPH	10.01.29
B	SHEET 3 ZONE C1, DIM 0.05 MIN WAS 0.13, MULTIPLE DIMENSIONS MINMAX REMOVED TOLERANCE ADDED. REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY.	AJS	09.11.11
A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION		
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>99</i>	DRAWING NO.	
MFG. APPR.	<i>3</i>	D3953	
APPROVED	<i>4</i>	REV. C	
DE APPR.	<i>7</i>	SHEET 1 OF 4	
DATE	10.01.29	TITLE	
		SCALE	
		GAS SPRING LID COMPONENTS	
		NTS	
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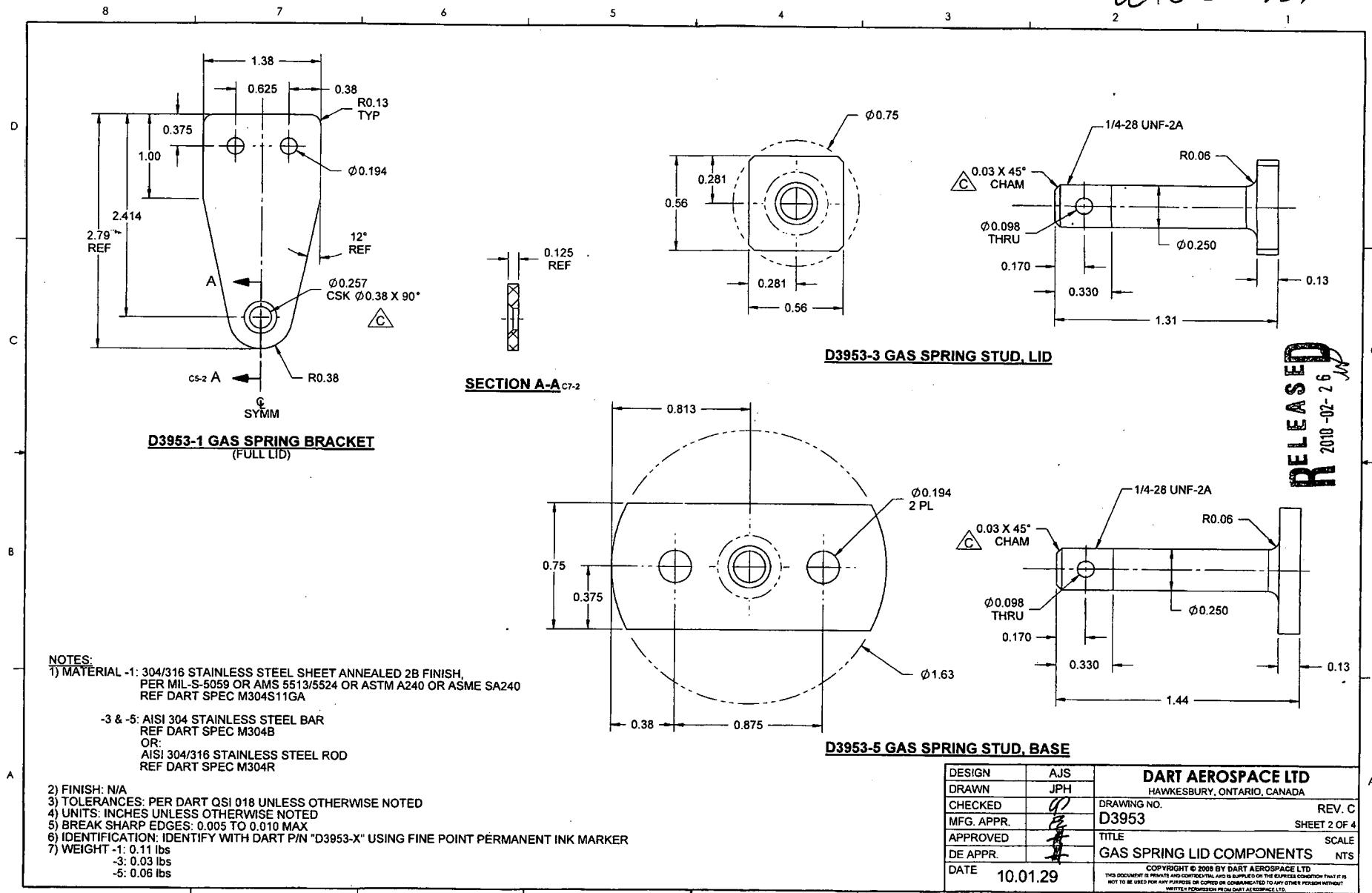
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

W/0 59437



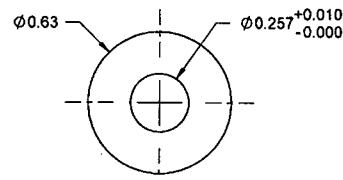
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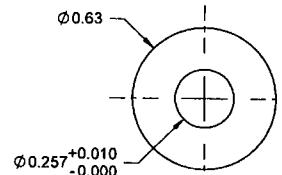
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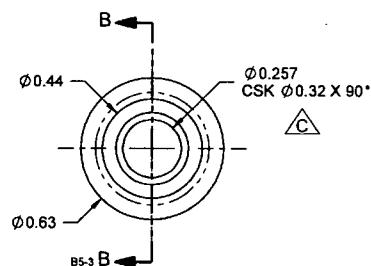
NOTE: Date & initial all entries



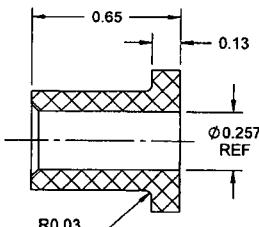
D3953-7 GAS SPRING SPACER



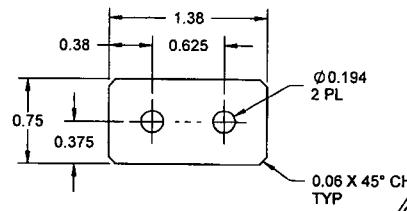
D3953-9 GAS SPRING WASHER



D3953-11 GAS SPRING SPACER



SECTION B-B B7-3



D3953-13 GAS SPRING SPACER

NOTES:

1) MATERIAL -7,-9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELIN-R

-13: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -7-9-11: < 0.01 lbs EACH

-13: 0.17 lbs

wb 59437

RELEASED
2010-02-26
100

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	99	DRAWING NO.	
MFG. APPR.	83	REV. C	
APPROVED	10	D3953	
DE APPR.	10	SHEET 3 OF 4	
DATE	10.01.29	TITLE	
		SCALE	
		GAS SPRING LID COMPONENTS NTS	
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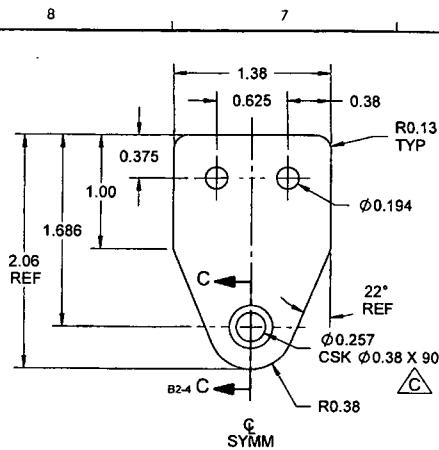
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

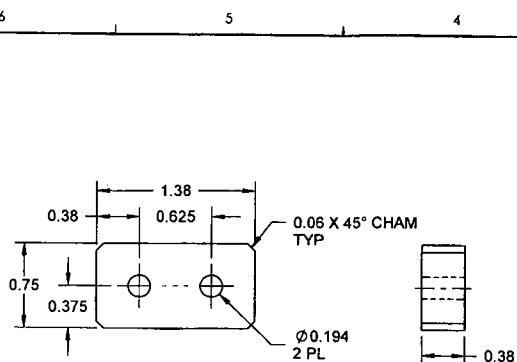
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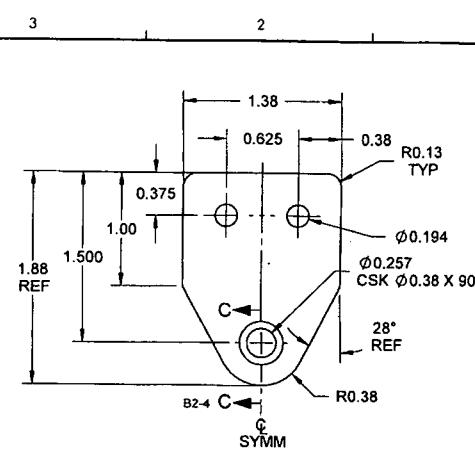
NOTE: Date & initial all entries



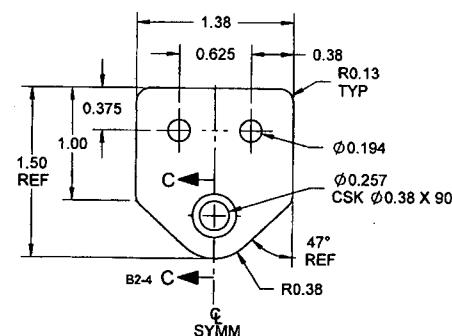
D3953-15 GAS SPRING BRACKET
(SPLIT LID)



D3953-17 GAS SPRING SPACER
(SPLIT LID)



D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)



D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)

w/039437

SECTION C-C C74
RELEASED 2010-02-26
C24 B24

NOTES:

- 1) MATERIAL -15-19-21: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA
- 17: AISI 304 STAINLESS STEEL BAR REF DART SPEC M304B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -15: 0.08 lbs
-17: 0.10 lbs
-19: 0.07 lbs
-21: 0.06 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>Q</i>	DRAWING NO.	
MFG. APPR.	<i>B</i>	D3953	
APPROVED	<i>S</i>	REV. C	
DE APPR.	<i>A</i>	SHEET 4 OF 4	
DATE	10.01.29	TITLE	
		SCALE	
		GAS SPRING LID COMPONENTS	
		NTS	

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